

Work Order ID 83568

83568

Page 1

Thursday, April 19, 2012 3:38:56 PM

Item ID: D350-604-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Rear Locker Extender

Start Date: 4/19/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/18/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *l*

Date: *1204-19* Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2273	<i>AB F</i>
-------	-------------

D350-604-041	B
--------------	---

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D350-604-041 CHG004

0.00

0.00

110

110

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: *46755 17636*

Description: D350-604-041 Rear locker extender.

Supplier: Delastek.

Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B

4 x 2600-LW Retaining washers - Ship to Delastek B

0.00

0.00

DA 16 17/04/25

Order MJS 12-9-25

CA 12/04/23 12/09/12

#31

121287 122335 121524

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83568***83568***

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rear Locker Extender

Start Date: 4/19/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/18/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120	Packaging								
Packaging	Memo	0.00							
Packaging	Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control	Check hole locations to template. DT 8824 Check process sheet and audit.								
140		0.00							
140									
Small Fab	Memo	0.00							
Small Fab	INSTALL DECALS AS PER DWG								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID 83568

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Page 3

Thursday, April 19, 2012 3:38:56 PM

Item ID: D350-604-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rear Locker Extender
 Start Date: 4/19/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/18/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
160 *160* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D350-604-041 Location: _____ PPP Rev: _____	0.00 0.00							
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							



17/09/25

42/9/25

12/9/25

MF
1209-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, April 19, 2012 3:39:00 PM

Work Order ID: 83568

83568

Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 4/19/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF IPP REV:R
12.02.07 AS PER ECN12-521 DD verf:JLM IPP REV:S 12.04.04
AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2269

Manufactured No

Each 28.0000

1

D2269

Decal

**

sp

Location

Loc Qty

Loc Code

ST007

20

80011

20

ST009

8

78920

8

2600-6

Purchased No

110

Each 131.0000

4

4

2600-6

Camlock Stud

**

CL 12/10/12

12/09/12

Location

Loc Qty

Loc Code

ST380

36

120077

36

ST381

95

121287

95

2600-LW

Purchased No

110

Each 111.0000

4

4

2600-LW

Camloc Retaining Washer

**

CL 12/10/12

Location

Loc Qty

Loc Code

ST381

100

121287

100

ST398

11

120648

11

122452
m 12/10/12 x4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 2

Thursday, April 19, 2012 3:39:00 PM

Work Order ID: 83568

83568

Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 4/19/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

D350-604-041P

Purchased

No

110

Each

0.0000

1

1

D350-604-041P

Rear Locker Extender

**

83568

D2268

Manufactured

No

140

Each

33.0000

1

D2268

Decal

**

54

Location

Loc Qty

Loc Code

ST007

20

80010

20

ST009

13

69592

2

78908

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

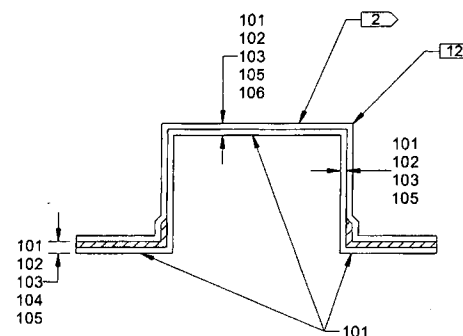
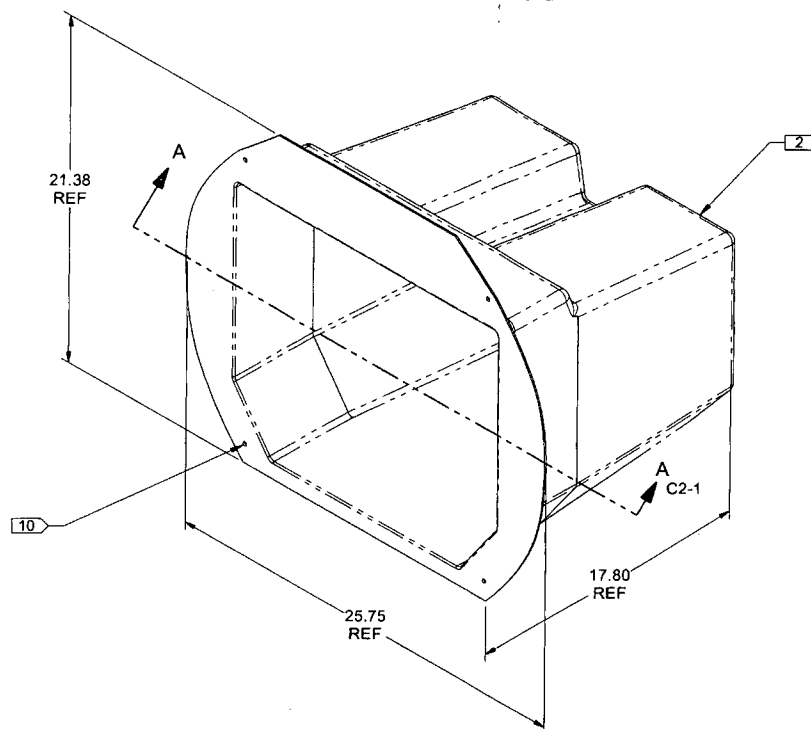
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83568

12-04-10



SECTION A-A
C4-1

RELEASED
2012-03-29

NOTES:

1) MATERIALS:

RESIN: DERAKANE 470-36/411/510A40
FIBRE: 9 oz = 9.7 oz 7781 WEAVE "S" GLASS
18 oz = 18.0 oz ROVING "E" GLASS

2) FINISH: FINISH THIS SURFACE WITH DUPONT GREY PRIMER LE 3404-S/LE 1175-S Δ

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1

7) WEIGHT: 7.75 lbs

8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.

9) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACUUM

10) TRIM & DRILL PER DT8020. OPEN HOLES TO \varnothing 0.257 (4 PLACES)

11) CONSTRUCTION:

101-WHITE GLOSS GELCOAT # GEL 2330PAWK745 TO MIN THICKNESS OF 0.020

102-9 oz ALL OVER

103-18 oz ALL OVER

104-18 oz REINFORCE FRONT FLANGE EXTENDING 2" ON SIDES

105-9 oz ALL OVER

106-PEEL PLY

12) MATTE TO HOLD DOWN CORNERS AS REQUIRED

D2273 REAR LOCKER EXTENDER

F	PRIMER LE 3404-S/LE 1175-S WAS 1144-S, ZN A6-1	DC	12.02.27
E	CHANGED SURFACE FINISH FROM 944W005 GELCOAT TO 2330PAWK745 GELCOAT, ZN A7-1. UPDATED DWG TO CURRENT STANDARDS.	DC	12.02.02
D	REMOVE EPOCAST. ADD SURFACE FINISH	CP	02.04.01
C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.30
B	RE-DRAWN	MM	96.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	BC	DRAWING NO.	REV. F
MFG. APPR.	BC	D2273	SHEET 1 OF 1
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	350 REAR LOCKER EXTENDER	NTS
DATE	12.02.27	<small>COPYRIGHT © 1986 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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NOTE: Date & initial all entries

Linda Lacelle

From: dshepherd@dartaero.com
Sent: April-03-12 1:38 PM
To: Daniel Campbell; 'Linda Lacelle'
Cc: Harvey Siemens; Chantal Lavoie
Subject: Re: ECN D2273

Dan,

I think Delastek is confused. Leave the dwgs for now ... I don't care whether we use Rev E primer or Rev F primer ... My understanding is that your Rev F dwg represents what is procurable going forward.

David

Sent from my BlackBerry device on the Rogers Wireless Network

From: "Daniel Campbell" <dcampbell@dartaero.com>
Date: Tue, 3 Apr 2012 10:42:39 -0600
To: 'Linda Lacelle' <llacelle@dartaero.com>; <dshepherd@dartaero.com>
Cc: Harvey Siemens <hsiemens@dartaero.com>; Chantal Lavoie <clavoie@dartaero.com>
Subject: RE: ECN D2273

Hi,

I'm a little confused about this.

I thought we had checked back in Feb. and the 7704-S was discontinued and replaced with LE-3404-S / LE1175-S ?

Anyway, I can go back and update the following to call out 7704-S:

D604-350

1. D2273
2. ICA-D350-604

D605-206

1. D2566
2. ICA-D605-206

I'm not sure if David is flying today - we might have to wait for him to weigh in.

Thanks,

Dan

From: Linda Lacelle [<mailto:llacelle@dartaero.com>]
Sent: April-03-12 10:00 AM
To: dshepherd@dartaero.com; Daniel Campbell
Subject: FW: ECN D2273

From: Jocelyne Laurin [<mailto:JLaurin@delastek.com>]
Sent: April-03-12 11:30 AM
To: Linda Lacelle
Cc: 'Chantal Lavoie'; Céline Audet
Subject: ECN D2273

Hello Linda,

For the Gel Coat we are presently using N° 2330PAWK745, Gel Coat Polycore Fireblock and for the primer Dupont Primer N° 7704S. Thank you and have a nice day.

Jocelyne Laurin

Agente Service à la clientèle/Customer Service Agent

DELASTEK INC.

jlaurin@delastek.com

De : Linda Lacelle [<mailto:llacelle@artaero.com>]

Envoyé : 2 avril 2012 14:54

À : Jocelyne Laurin; 'Chantal Lavoie'

Cc : David Paradis; Céline Audet

Objet : RE: ECN D2273

Importance : Haute

Jocelyne,

This is the current primer you are using. We need to understand exactly what you are currently using. Please DO NOT stop production on the parts to ship this Thursday.

L

From: Jocelyne Laurin [<mailto:JLaurin@delastek.com>]

Sent: April-02-12 10:18 AM

To: 'Chantal Lavoie'; Linda Lacelle

Cc: David Paradis; Céline Audet

Subject: ECN D2273

Importance: High

Hello Chantal,

Before we can ship the rearlockers at rev. F, (for order attached), we have to analyse the implications, so the confirmed dates no longer stand, since they were for revision E. As soon as the analysis is completed we will forward a new quote (if applicable) as well as the new delivery dates, unless you want them at Rev. E. Please advise ASAP as they are being produced at the moment. Thank you so much and have a nice day.

Jocelyne Laurin

Agente Service à la clientèle/Customer Service Agent

DELASTEK INC.

jlaurin@delastek.com

De : Chantal Lavoie [<mailto:clavoie@dartaero.com>]

Envoyé : 30 mars 2012 10:38

À : Jocelyne Laurin

Cc : Lacelle, Linda

Objet : ECN D2273

Hi Jocelyne,

Please see attached for new revision for rearlocker they are now at rev. F.

Thanks

Chantal

No virus found in this message.

Checked by AVG - www.avg.com

Version: 2012.0.1913 / Virus Database: 2114/4912 - Release Date: 04/03/12



Certificate of Conformance

Solve Composites

29 Distribution Way

Plattsburgh, New York, 12901

USA

Dart Aerospace Order Number: 17636

Part Number: D2273

Quantity: 1

Drawing Number: D2273, DT8020

Serial Number (s): 0030, 0031, 0032, 0033, 0034

Date: September 24, 2012

Non-Conformances: None

This is to certify that the parts identified above conform to all applicable drawings and/or specifications as evidenced by reports on file, and that all other purchase order and quality requirements have been met.

A handwritten signature in black ink, reading 'Jerry Reyell', written over a horizontal line.

Jerry Reyell

Project Manager

Solve Composites